

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003843**Date Inspected:** 02-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Kuan Chung**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower,Jacking and Deviation Saddle**Summary of Items Observed:**

The following report is based on METS observations at Japan Steel Works (JSW) in Muroran Japan. Current work: Casting, machining and repair of Saddles.

Fabrication Shop # 4

NDT Inspection

On this date the QA representative Dong J. Shin arrived at Japan Steel Works (JSW) of Muroran Japan and traveled to JSW fabrication shop # 4 and observed NISC NDT Technician Mr. K. Kobayashi and Mr. R. Kumagai perform Magnetic Particle testing on weld run out tab removal areas of casting W2E2. Magnetic particle testing was performed with yoke, AC current with red particles. JSW QC inspector Mr. Kuan Fu Chung observed NISC perform testing in progress and kept a record of test results. On 08-29-2008 the QA inspector did find out cracks at the run out tab removal area of rib to base plate of welds 2-4 and 2-17. JSW project manager Mr. Sato placed a call to Mr. Sibuyah(PhD, NISC General manager) to perform SUMP(Suzuki universal macro printing) testing for future investigation on afternoon of 29-08-2008.

After SUMP testing, JSW started grinding for verification of depth of crack, around 2mm ground down,the crack disappeared.

On 09-02-2008, QA Inspector had short meeting with Mr. Sato (Project manager), Mr. Kuan (QC Inspector}, Mr. Maruya(Welding engineer), Mr. Nagaya (Project Engineer) and Mr. Kon (Project engineer)

During this meeting Mr. Sato stated that the indication was HAZ crack based on Mr. Sibuyah's SUMP test result.

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## WELDING INSPECTION REPORT

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### Mechanical Test Witness

The QA inspector observed three each Macro Etch tests for test plates for welding procedure specification SW-13-1, SW-13-2 and SW13-3. JSW QC personnel Mr. Naoya Takahashi performed tests and recorded results as acceptable in accordance with paragraph 5.19.3.

### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Shin,DJ	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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